

ABSTRACT

A method of machining a work in a numerically controlled lathe is provided which is capable of reducing the machining cost by shortening idle time at the time of switching and which is capable of enhancing the lifetime by lessening a load on a feeding mechanism of a tool rest.

After completion of the machining of a work W with a tool T1 on one tool rest (13), the one tool rest (13) is moved to a standby position B and, at the same time, the other tool rest (15) is moved from a standby position D and the feed speed of the other tool rest (15) is controlled such that the one and the other tool rests (13, 15) simultaneously reach positions C and F preset between the work W and the standby positions B and D.